

**Work Order ID 76931**

Thursday, November 24, 2011 8:56:08 AM

**\*76931\***

Page 1

Item ID: D3372-041

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Collective Lock Assembly

Stop

**\*NS2\***

Start Date: 11/24/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: *MFC*

Date: 11-11-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3372	Rev B
-------	-------

100	Small Fab	0.00
-----	-----------	------

<b>*100*</b>	<b>Small Fab</b>	0.00
--------------	------------------	------

Small Fab	<b>Memo</b>	0.00
	Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372	
	Identify as D3372-3	

110	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

<b>*110*</b>	<b>QC</b>	0.00
Quality Control	<b>Memo</b>	

120	Small Fab	0.00
-----	-----------	------

<b>*120*</b>	<b>Small Fab</b>	0.00
Small Fab	<b>Memo</b>	0.00
	1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.	
	2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5	

*UNAUKB*

Run

Start

**\*NR1\***

Stop

**\*NR2\****SJ 11/11/24**SJ 11/11/25**(1)**SJ 11/11/25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, November 24, 2011 8:56:07 AM

Page 1

**Work Order ID:** 76931

**Parent Item:** D3372-041

**Start Date:** 11/24/2011

**Required Date:** 11/25/2011

**Parent Item Name:** Collective Lock Assembly

**Start Qty:** 1.00

**Required Qty:** 1.00

**Comments:** IPP Rev:A Removed from 9 Digit 06-01-13 JLM  
IPP Rev:B Added Key ID \_\_\_\_\_ 06.03.21 EC  
10.05.13 verified :EC

IPP Rev:C added D3384-043 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC SS Flat Washer 5/16 FW516S1		Purchased	No			100	Each	681.0000	2	2	SD	11/14/25	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST377			681			2			
				117332			87						
				119343			594						
AN5-42A Bolt		Purchased	No			100	Each	37.0000	1	1	SD	11/14/25	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST340			37			1			
				108442			17						
				119438			10						
				119449			10						
AN960-416 Washer	NAS1149F0463P	Purchased	No			100	Each	0.0000	2	2	SD	11/14/25	
D2728-7 Dart Logo label		Manufactured	No			100	Each	0.0000	0	0			
D3372-1 Main Body		Manufactured	No			100	Each	11.0000	1	1	SD	11/14/25	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST485			3			1			
				75126			3						
				ST491			8						
				75202			8						
D3372-5 Cam Lock Shaft		Manufactured	No			100	Each	8.0000	1	1	SD	11/14/25	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST048			8			1			
				76485			8						

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Thursday, November 24, 2011 8:56:08 AM

Page 2

Work Order ID: 76931

Parent Item: D3372-041

Start Date: 11/24/2011

Required Date: 11/25/2011

Parent Item Name: Collective Lock Assembly

Start Qty: 1.00

Required Qty: 1.00

D3372-7 Slider Body	Manufactured	No	100	Each	0.0000	1	1	SA 10/10/25
D3373-1 Cam Lock	Manufactured	No	100	Each	72.0000	1	1	SA 10/10/25

		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
D3384-043 Cyclic Sock Assembly	Manufactured	ST049	72				
		58463	2				
		74862	20				
		75666	50				

HX-81 1/4"-20 SHCS 3/8" long	Manufactured	No	100	Each	4.0000	1	1	SA 10/10/25
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST480	3	B77188				
		74729	3					
		ST486	1					
		70037	1					

	Purchased	No	100	Each	10.0000	1	1	SA 10/10/25
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST390	10					
		114383	10					

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

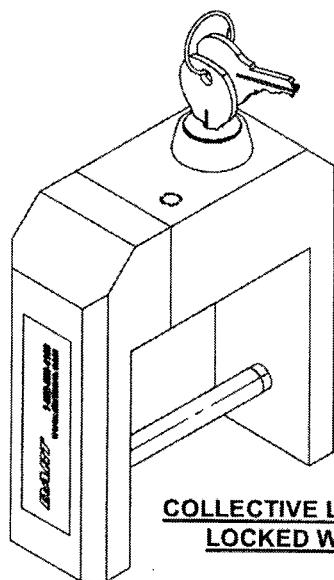
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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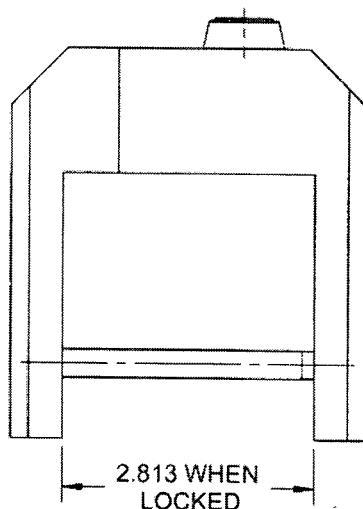
NOTE: Date & initial all entries



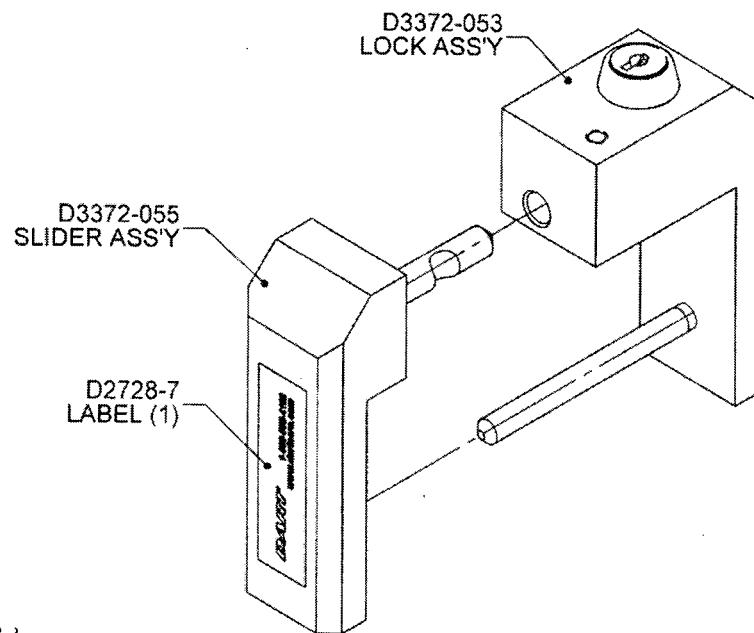
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CHECKED	APPROVED	DRAWING NO.	REV. B
		D3372	SHEET 1 OF 8
DATE	TITLE	SCALE	
05.02.23	COLLECTIVE LOCK	1:2	
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS



2.813 WHEN  
LOCKED



RELEASED  
05/04/28

### D3372-051 AS350 COLLECTIVE LOCK ASS'Y

#### NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

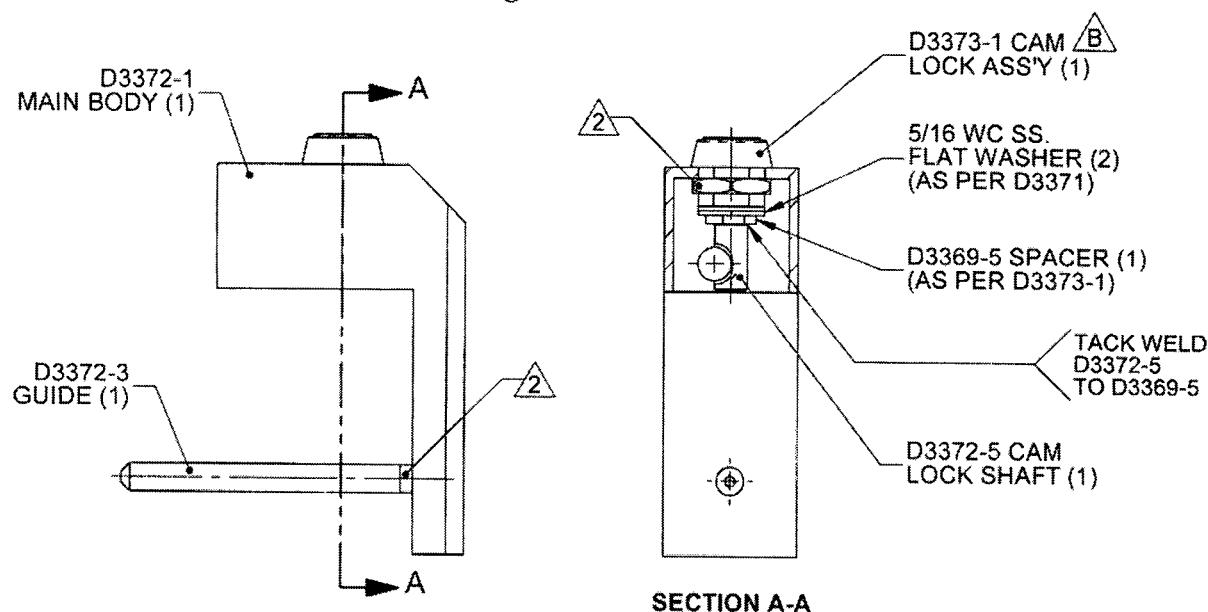
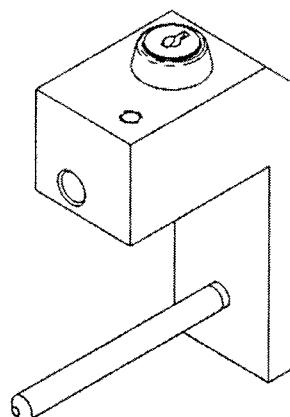
NOTE: Date & initial all entries



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CHECKED	APPROVED	DRAWING NO. D3372
DATE	05.02.23	TITLE COLLECTIVE LOCK

REV. B  
SHEET 2 OF 8  
SCALE  
1:2

RELEASED  
2/24/23



SECTION A-A

D3372-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

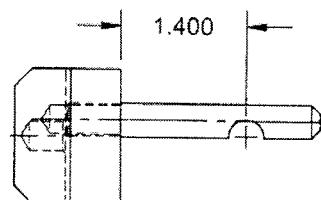
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

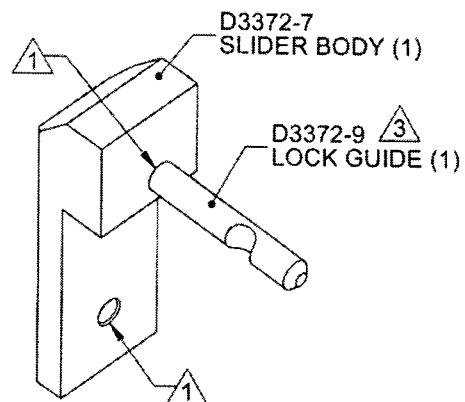
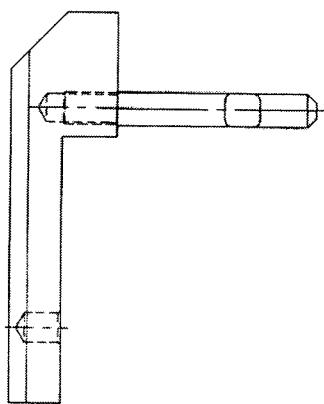
NOTE: Date & initial all entries



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CHECKED	APPROVED	DRAWING NO.	REV. B
RF	AM	D3372	SHEET 3 OF 8
DATE	05.02.23	TITLE	SCALE
		COLLECTIVE LOCK	1:2



RELEASED  
29/04/23



\* 1693

### D3372-055 SLIDER ASS'Y

#### NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



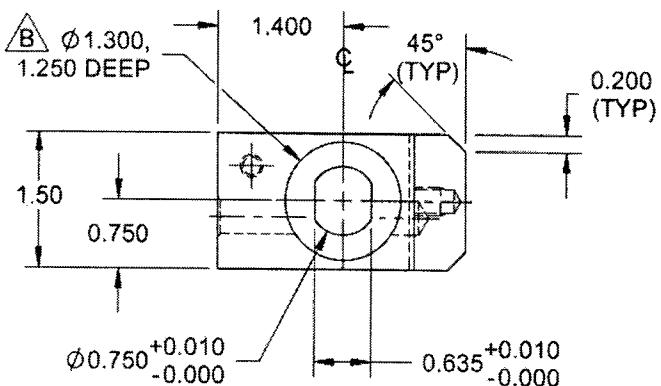
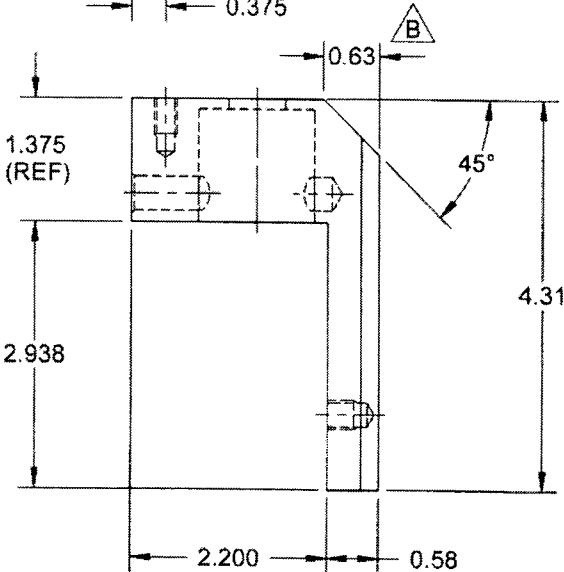
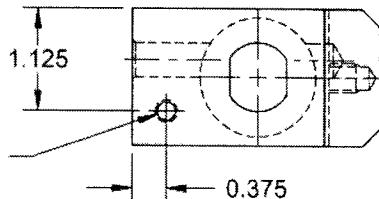
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CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 4 OF 8
DATE	05.02.23	TITLE	SCALE COLLECTIVE LOCK 1:2

RELEASED  
25/04/23

△ DRILL Ø 0.201 x 0.600 DEEP  
△ TAP 1/4-20 UNC x 0.400 DEEP

△ DRILL Ø 0.377,  
2.363 DEEP.  
CHAMFER 0.031 x 45°  
0.313  
0.564  
2.108  
0.750

△ DRILL "I" DRILL  
x 0.525 DEEP  
THREAD 5/16-24 UNF  
x 0.300 DEEP



### D3372-1 MAIN BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

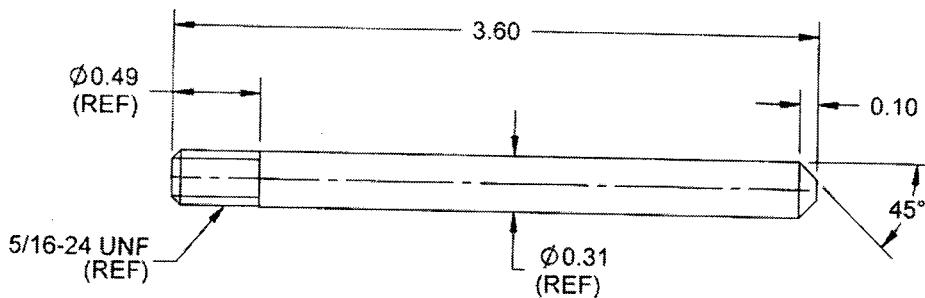
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CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 5 OF 8
DATE	05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:1

## SPECIFICATION CONTROL DRAWING

RELEASED  
05/04/23



# 7693

### D3372-3 GUIDE

#### NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

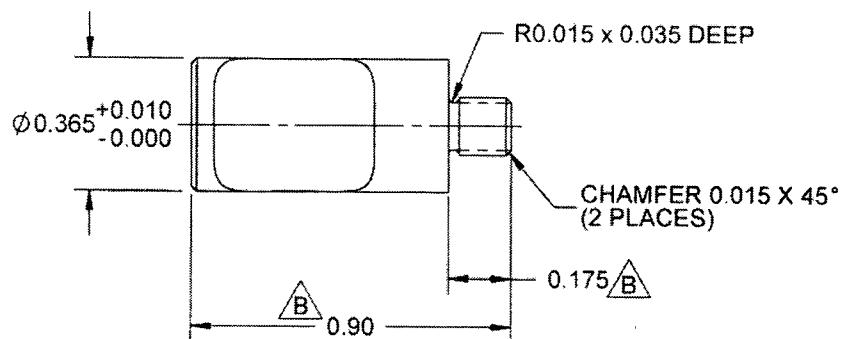
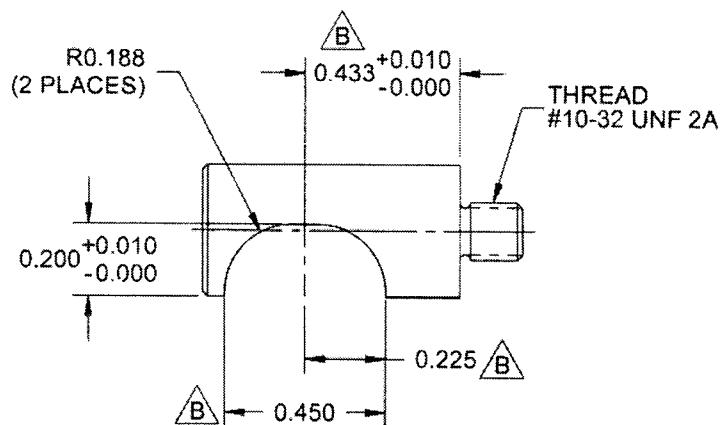
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	05.02.23	TITLE	SHEET 6 OF 8 COLLECTIVE LOCK 2:1

RELEASED  
05/04/28



#7693)

### D3372-5 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: NC Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

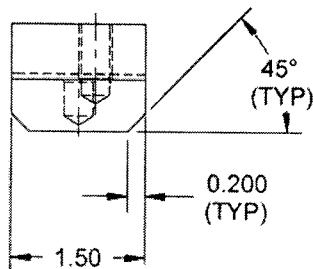
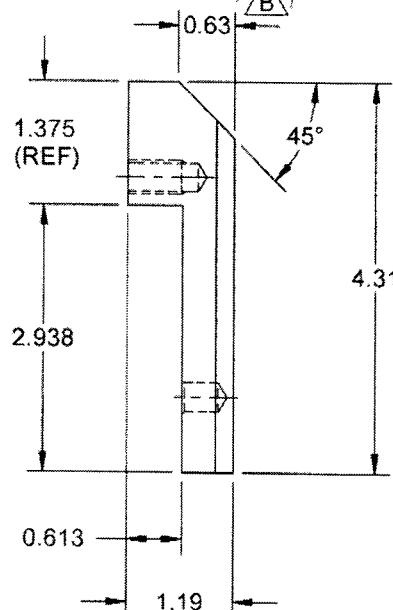
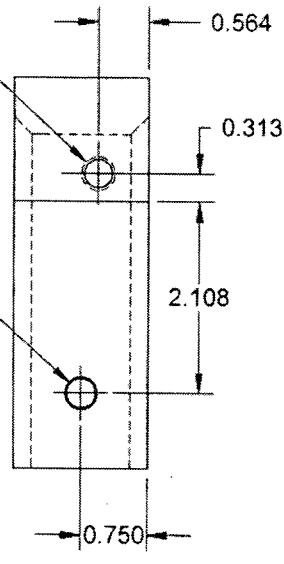
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 7 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2	

DRILL Ø0.332  
("Q" DRILL) x 0.881 DEEP,  
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL Ø0.323  
("P" DRILL) x 0.500 DEEP  
CHAMFER 0.030 x 30°



\* 76931

### D3372-7 SLIDER BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

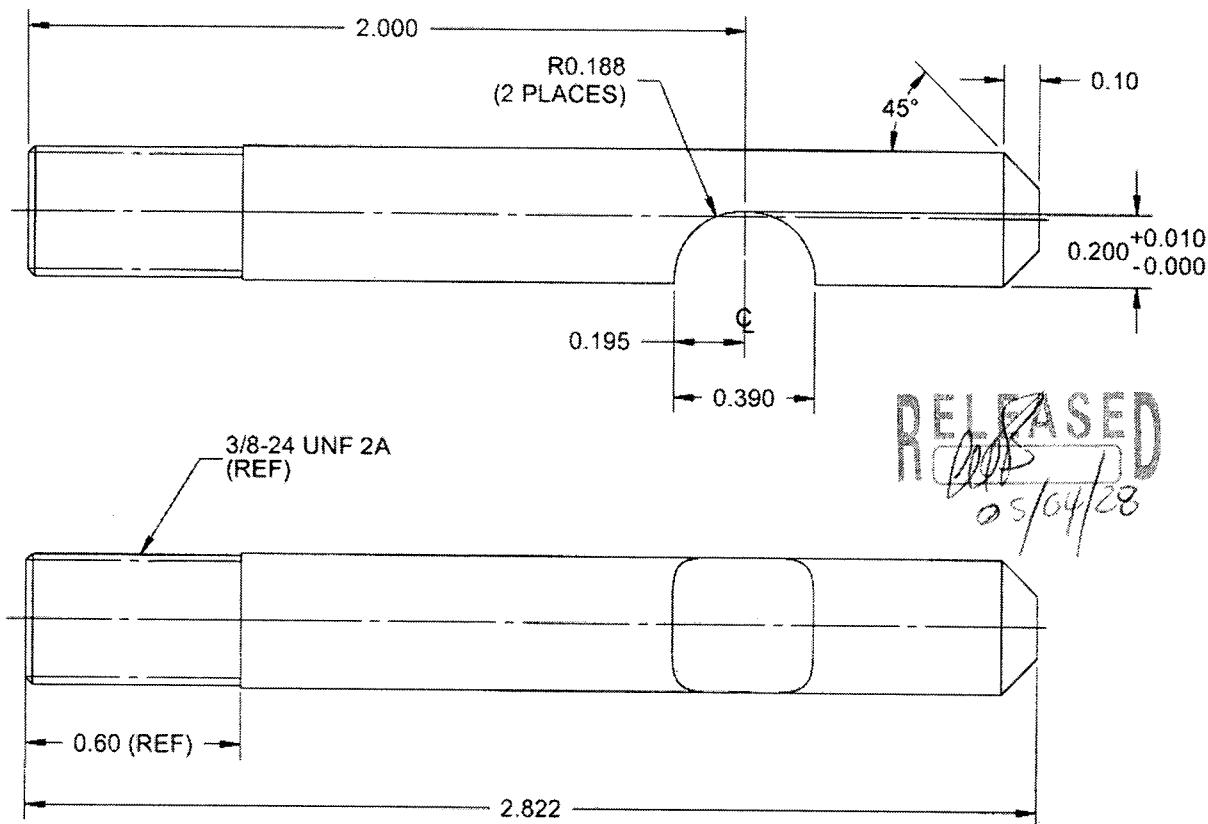
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3372	REV. B SHEET 8 OF 8
DATE	05.02.23	TITLE	COLLECTIVE LOCK	SCALE 2:1

## SPECIFICATION CONTROL DRAWING



# 7693)

### D3372-9 LOCK GUIDE

#### NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



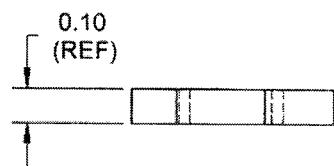
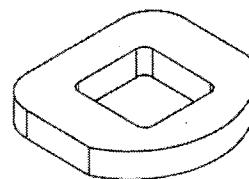
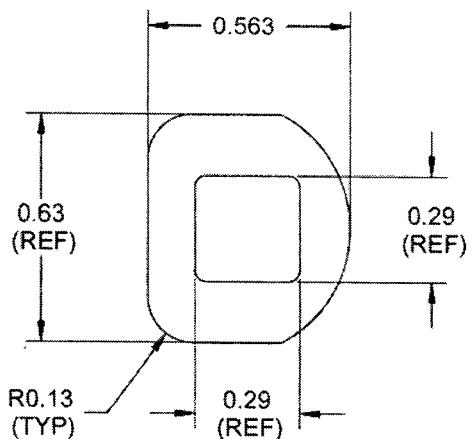
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3369	SHEET 4 OF 4

DATE 04.12.16 TITLE BATTERY LOCK SCALE 2:1

## SPECIFICATION CONTROL DRAWING

RELEASED  
RMB

05/04/11



CDU111124

W/D. 716931

<sup>5</sup>  
D3369 SPACER



### NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010